



Dart Aerospace Ltd.
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RBW109-3130-69-101

Job Sheet 185272



Part No: RBW109-3130-69-101

Job Qty: 1 ea

Part Name: Tail Rotor Pitch Change Housing, Duplex Bearing Install



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW109-3130-69-101 Rev.0 IPP Rev. A 18.10.19 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/14/18	0.00	0.00	Start Up Small Fab-2		MLC
110	Small Fab	1 pcs		11/14/18	0.00	1.00	Small Fab-3		MLC
120	QC	1 pcs		11/14/18	0.00	0.00	QC5	DAS 21 9-89	MLC
130	Packaging	1 pcs		11/14/18	0.00	0.00	Packaging3-1	DAS 21 9-89	MAR 19 2019
140	QC21-FG	1 Ea		11/14/18	0.00	0.00	QC21	DAS 21 9-89	MAR 19 2019

Part Op 110 - 1-Assemble as per DWG.
Descriptions:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW109-3130-69-101-1	Pin	1 Ea (1 ea)	90-Start up Operation	5130335
RBW109-3130-69-101-3	Base	1 Ea (1 ea)	90-Start up Operation	5130075

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBW109-3130-69-101-1	1	0	0
	RBW109-3130-69-101-3	1	0	0

Part Specifications

Specifications could not be found.



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Plex 10/24/18 12:34 PM Dart.lajeunesse.marie

Container No: S132035



Part: RBW109-3130-69-101

Job No: 185272

Serial No/Batch: S132035

Revision: 0

Inspector:

Exp Date:

Instructions:

Date: 11/27/18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



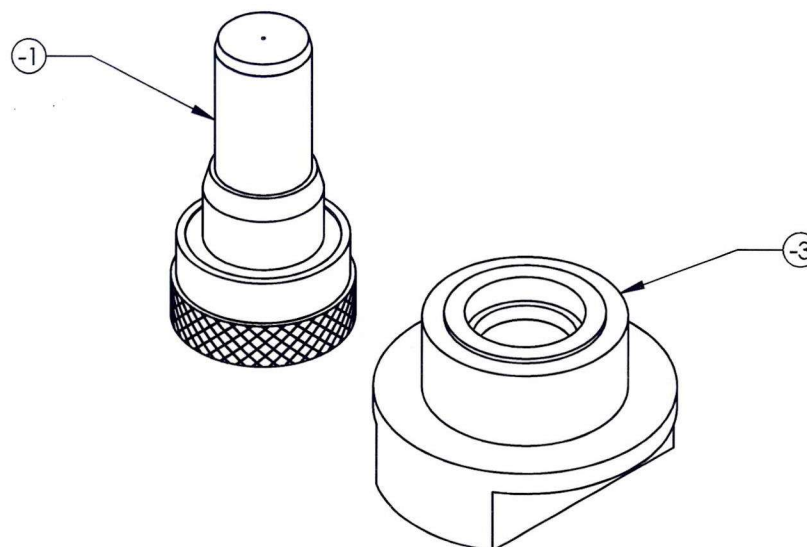
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL



SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185272 MWS

181024

REF: AGUSTA P/N 109-3130-69-101

RED BARN MACHINE	
TITLE TAIL ROTOR PITCH CHANGE HOUSING, DUPLEX BEARING INSTL	
DWG NO. RBW109-3130-69-101	REV
MAT'L	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1	APPROVED <i>D Weil</i>
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	HEAT TREAT FINISH SPEC
SCALE 1:3	USED ON MODEL AW109
DATE 4/4/2011	SHEET 1 OF 3

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	PIN	6061	Ø3 X 5-5/8 109-3130-69-105	2
			-3	1	BASE	6061	Ø5 X 3-1/8 109-3130-69-103	3